| | lednesday, 06/08/2008 10:34:57 AM felanie Fauteux | Process Sheet | AS | AP |
|---|--|---|---|------------|
| Customer Job Number | : CU-DAR001 Dart Helicopters Services : 41009 | Drawing Name | : 412 SKI WEARPLATE | |
| Estimate Number P.O. Number This Issue Prsht Rev. | : : 06/08/2008 | Part Number Drawing Number Project Number | r : N/A | |
| First Issue Previous Run Written By Checked & Appre | : // Type : R & D SM/MI : (| IED FAB Drawing Revision Material Due Date | on : PRELIM : : : : : : : : : : : : : : : : : : : | 2 Um: Each |
| Comment | : Est Rev:A 08-08-05 new issu | ue DD verified by:ec | | • |
| Additional Produ | ct | PR | ELIMINARY ISS | UE |
| Job Number: | | | | |
| Seq. #: | Machine Or Operation: | Description : | | POSIT |
| 1.0 | M304S16GA | 304/316 Sheet .063 | | L VE |
| | NE OPRENE CHE ET 0.063 304 batch: 108724 12 8 | 4.1538 sf(s) | X (· / | |
| 2.0 | WATER JET | FLOW WATER JET | | |
| oon. | nment: FLOW WATER JET 1-Cut as per Dwg D3796 Dwg Rev: PRE L R 8- Prog Rev: PEEL | 8-6 | | 3 |
| i ndaha | 2-Deburr if necessary R 9- | | | |
| 3.0 Com | QC2 L报 8- ment: INSPECT PARTS AS THEY COME O | inspect parts as they col -86 DFF MACHINE | ME OFF MACHINE | |
| 4.0 Comi | QC8 | SECOND CHECK | a/66(×3) | |
| 5.0 ; | D30093 ment: Qty.: 12.0000 Each(s)/Unit Total | Cup | | |
| | Cup 34 37489 | 1 1 1 × 40613 | EL | 8-8-7 |
| | | | | |

Process Sheet

Drawing Name: 412 SKI WEARPLATE

Part Number: D3796041

Job Number:



Seq. #: **Machine Or Operation:**

Description:

6.0

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Hadcoof 2059B

Weld hardcoat and cups as per dwg D3796

QC9 7.0





Comment: VISUAL WELDING INSPECTION

INSPECT WORK TO CURRENT STEP

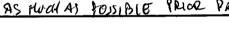
ENGINEERING APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

STRAIGHTEN PORTS

PACKAGING RESOURCE #1



PACKAGING 1 9.0

QC5



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

10.0

QC21

Comment: FINAL INSPECTION/W/O RELEASE

FINAL INSPECTION/W/O RELEASE

Job Completion



Powder cost gray

| DARTAEROSPACE LTD | Work Order: |
|-------------------------------------|----------------------|
| Description: 417 SKI WEAR PLATE | Part Number: D3796-1 |
| Inspection Dwg: D3796-1 Rev: ORELIM | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|--------------|---------------------|----------|--------|-------------------------|----------|
| \$.879 | 1,010 - ,001 | .886 | X | | | |
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| 9,000 | th .00 | | ¥ | | | |
| 10.747 | +/010 | | X | | | |
| 8,500 | 1/2 ,010 | O - | Ø | | | |
| 17 am | 4010 | 17.000 | 20 | | | |
| 34.700 | 1/2 .010 | 34.200 | * | | | |
| 45,12 | 4- 530 | 45.17 | x | | | |
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| Measured by: | 18 | Audited by: | 8. | , | Prototype Approvai: | |
|--------------|-------|-------------|------|---|---------------------|--|
| Date: | 8-8-6 | Date: | 2/8/ | 6 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| Α | | New Issue | KJ/JLM | |

| W/O: | | WORK ORDER CHANGES | | | | | | |
|-------|------|-------------------------------------|----|----------|-----|-------------------------------|-------------------|--|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Appro QC Inspe | |
| 80811 | 60 | took PIECE TO FABRICATE JIG DT 9037 | ta | 08-08-11 | V | 20016 | 100000 | |
| | | | | | | | | |

WORK OPDED NON CONFORMANCE (NCR)

| NCR: 4 | 1009 | WC | DRK OR | DER NON-CONFORMANCI | = (NCR) | | | |
|----------|------|---|-----------------------|---|----------------|--------------|-----------|--------------|
| | | Description of NC | | Corrective Action Section B | | Verification | Approval | Approval |
| DATE | STEP | Description of NC Section A | Initial Chief Eng) | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | QC Inspector |
| 06 06-18 | 6-0 | Parts were worping. during welding, consing them not to fot during installation. R.C. Do Jig to held them | Jasian Chat | - Much DT 9040 - Scrippi closticy and 2 i Replace | B 8-V-19 | 104508-18 | losione, | 104:08:18 |
| | | | | | | | | |
| | | | | · | | | | |

NOTE: Date & initial all entries